

Work Order ID 69341

Monday, May 09, 2011 11:34:17 AM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

11/07/07

H. For CL 11-7-4 (P) →

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14039
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

11-05-9 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-588-041 PAR #: _____ Fault Category: Production Engineering NCR: Yes No QA Date: _____
 Resolution: Revised Disposition: Revised QA: N/C Closed: _____ Date: _____

NCR: <u>69341</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/17/7</u>	<u>155</u>	Missing Qty x16 A1960 JDS from Pick list for Kit on degen #155 R.C. w/o + Bom not Correct.	<u>W</u> <u>11/17/7</u>	→ ADD Qty x16 A1960 JDS (per quantity) N1551149 DUBB <u>117316</u>	<u>11/17/7</u> <u>SP</u>	<u>S</u> <u>11/17/7</u>	<u>W</u> <u>11/17/7</u>	<u>S</u> <u>11/17/7</u>
				→ correctly update w/o + Bom to have A1960 JDS in two location ① - Assembly = Qty, 8				<u>S</u> <u>11/17/7</u>
				② - Pick kit = Qty x16 ADD copy of updated Bom for Ref. <u>Intuitive 500M</u>				<u>S</u> <u>11/17/7</u>

NOTE: Date & initial all entries

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Item ID: D350-588-041

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Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

CD 4/10/24 0

11 06 28 ①

BT 11.06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start



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Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11 06 29 ①

155

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/68

160

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/07

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-588-041

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Setup Start

Revision ID:

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Item Name: Aft Door Assembly

Start Date: 5/9/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: <u>43</u> Memo	0.00 0.00							
180  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

READ

11/2/78

CK 4/07/08
MF

11-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Monday, May 09, 2011 11:34:25 AM

Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149DN832J WASHER		Purchased	No			#140	Each	1,358.000	8	8		8T 11-06-28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST297				1358					
					117316			1358		x24			
D2445P AFT DOOR ASSEMBLY		Purchased	No			110	Each	0.0000	1	1		69342 8T 11-06-28	
AN526C832R9 Screw		Purchased	No			140	Each	603.0000	8	8		8T 11-06-28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST327				603					
					117010			7					
					117619			196		x8			
					117628			400					
AN960JD10 Washer	NAS1149D0363J	Purchased	No			140	Each	0.0000	2	2		8T 11-06-28	
D2143 Hinge Bracket		Manufactured	No			140	Each	31.0000	1	1		8T 11-06-28	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST198				31					
					64308			31		x1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2144

Manufactured No

140 Each

20.0000 1 1



Hinge Bracket



RT 11-06-28

Location

Loc Qty

Loc Code

ST198

20

64778

20

XL

D2463

Manufactured No

140 f

555.0600 7.25 7.25



Seal



RT 11-06-28

Location

Loc Qty

Loc Code

ST404

555.06

64944

62.66

66954

492.4

x 7.25

(D2463-0870) cut (1) at 87.00"

**** per kit****

D2585

Manufactured No

140 Each

41.0000 2 2



Mounting Channel



RT 11-06-28

69536

Location

Loc Qty

Loc Code

ST017

41

66142

41

D2586

Manufactured No

140 Each

107.0000 2 2



Door Latch



RT 11-06-28

Location

Loc Qty

Loc Code

ST204

107

64656

7

64774

100

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2621

 Latch Plate, 350 Spacepod

Manufactured No

140 Each

42.0000

2 2



RT 11-06-28

Location

Loc Qty

Loc Code

ST019

42

56526

42

X2

D2857-1

Manufactured No

140 Each

1.0000

1

1


 Hinge Bracket

66983



RT 11-06-28

Location

Loc Qty

Loc Code

ST024

1

64435

1

D2857-2

Manufactured No

140 Each

21.0000

1

1


 Hinge Bracket



RT 11-06-28

Location

Loc Qty

Loc Code

ST024

21

64463

11

65091

10

X1

MS21042L08

Purchased No

140 Each

303.0000

8

8


 Nut

117677



RT 11-06-28

Location

Loc Qty

Loc Code

ST300

303

117087

6

117441

97

117601

200

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

2,400.000

2

2



Nut



ST 11-06-28

Location

Loc Qty

Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

x2

MS27039-1-15

Purchased

No

140

Each

100.0000

2

2



Screw



ST 11-06-28

Location

Loc Qty

Loc Code

ST292

100

116916

100

x2

AN526C1032R7

Purchased

No

155

Each

76.0000

2

2



Screw



i2

Location

Loc Qty

Loc Code

MEZZ

2

113064

1

113749

1

ST328

74

116304

74

2

AN526C832R8

Purchased

No

155

Each

33.0000

8

8



Screw



m117688 11/7/09

Location

Loc Qty

Loc Code

ST327

33

116471

33

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

155 Each

0.0000

2

2

Washer

D2150

Manufactured No

155 Each

9.0000

2

2

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

9

64764

9

Manufactured No

155 Each

17.0000

2

2

D2151

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST006

17

64776

17

Manufactured No

155 Each

26.0000

1

1

D2153

Door Prop

Location

Loc Qty

Loc Code

ST272

26

64943

26

Manufactured No

155 Each

34.0000

1

1

D2154

Stud Bracket

Location

Loc Qty

Loc Code

ST006

34

64312

34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

155

Each

66.0000

2

2



Striker Plate

Location

Loc Qty

Loc Code

ST009

66

64762

2

66139

64

D2461

Manufactured No

155

f

196.5000

7.25

7.25



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

196.5

39782

6.5

55054

4

63880

186

(D2461-0870) cut (1) at 87.00"

**** per kit***

D2589

Manufactured No

155

Each

110.0000

1

1



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

110

58194

110

D2690-17

Manufactured No

155

Each

22.0000

1

1



Cable

Location

Loc Qty

Loc Code

ST020

22

64786

1

66510

21

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69341

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2858-1 Manufactured No

155

Each

11.0000

1



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64785

11

D2858-2 Manufactured No

155

Each

11.0000

1



Hinge Bracket

Location

Loc Qty

Loc Code

ST024

11

64787

11

FG-778150-550-ROL Purchased No

155

sf

2,673.970

1



7781 9oz Glass 50"x125yd

Location

Loc Qty

Loc Code

CA

1649.97

117602

1649.97

ST404

1024

104845

3

108932

18

111166

392

113905

611

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4 Purchased No

155

Each

5,258.000

12



RIVET

Location

Loc Qty

Loc Code

ST316

5258

104374

1258

110398

4000

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Work Order ID: 69341

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Parent Item Name: Aft Door Assembly

Start Date: 5/9/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

155

Each

1,533.000

18

18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1533

116410

14

116893

1519

MS21042L08

Purchased

No

155

Each

303.0000

10

10



Nut

Location

Loc Qty

Loc Code

ST300

303

117087

6

117441

97

117601

200

MS21042L3

Purchased

No

155

Each

2,400.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

2400

116391

11

116540

423

116549

766

117441

800

117601

400

MS27039-08-11

Purchased

No

155

Each

183.0000

2

2



Screw

Location

Loc Qty

Loc Code

ST290

183

116289

33

117441

150

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

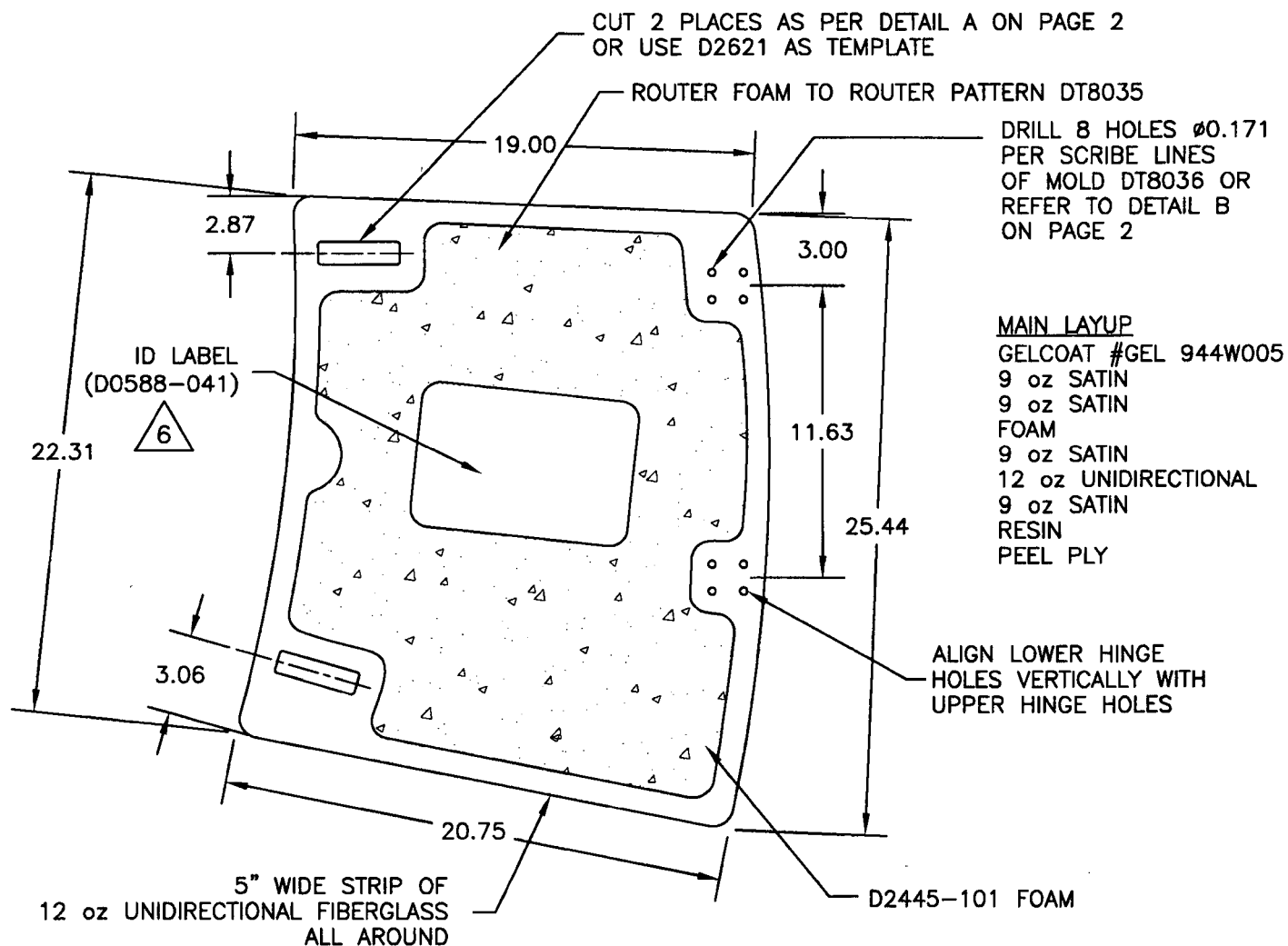
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMNYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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69341

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

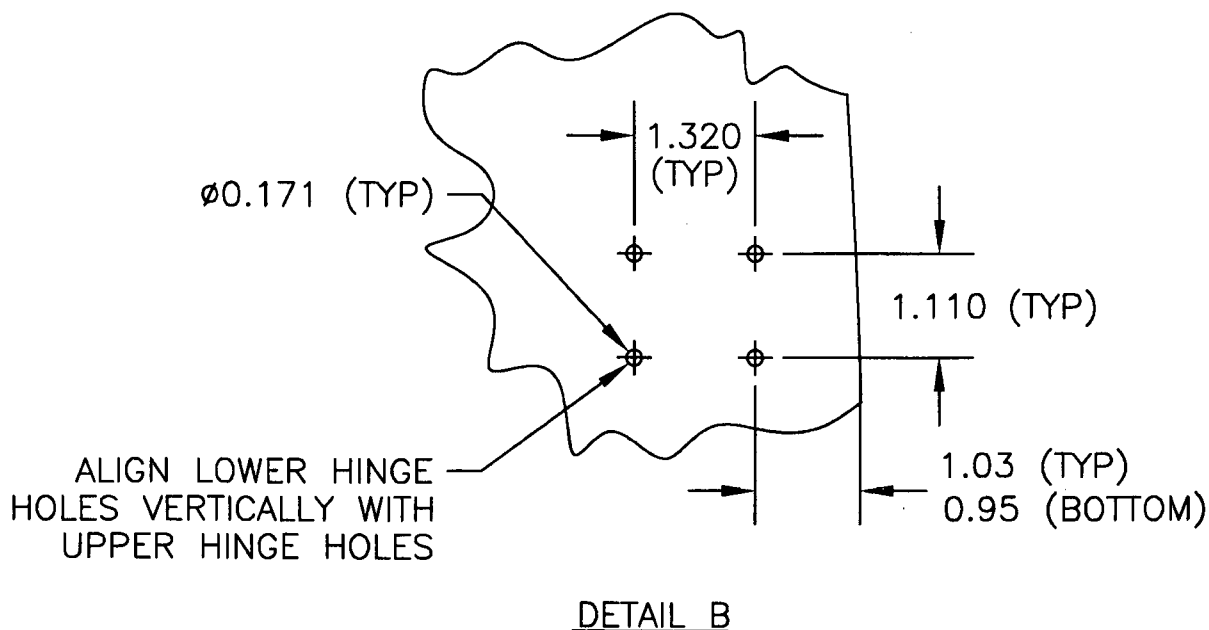
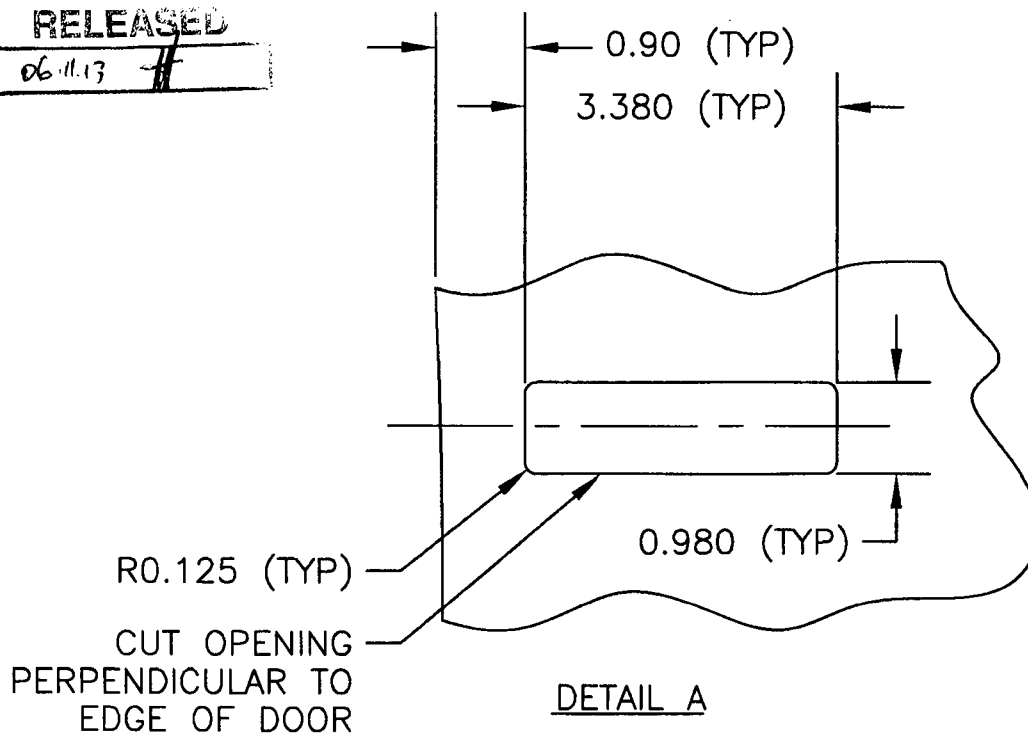
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	39059
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN



Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX PI Collect ✓		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
23/06/2011	09/05/2011	17521	Brigitte Golden	14039			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	Line 1 D350-588-041 Aft Baggage Door (D2445) B69341 U de M : Each Drawing N° : D2445 Rév.: D No. série No. lot B69342 B69341 33206 SB 27/06/2011 SHIP 23 JUN 2011 7948-9921-3624 FED-PI			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☒ Ship.

Accepted by:

Quality department

AQ-357




Date: Lundi, 2011-05-09 17:47:01
 Utilisateur: Pascal Carignan

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	N° D2445, AFT BAGGAGE DOOR
Numéro Job :	33206	Numéro Article :	DKC134-0013
Numéro Soumission :	3959	Numéro Dessin :	D2445
Numéro B.A. :	Kit 854	Projet Numéro :	DK-134
Cette fois :	2011-05-09	Révision dessin :	D
Prsht Rev. :	NC	Matériel :	Composite
Prem. fols :	- -	Date Dûe :	2011-05-16
Job précédente :	33205	Qté:	1 Udm. UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Client: D2445		

Process Sheet Rév.: 01 changer le sikkens AAC1390 pour le P15-3 (AAC1492), enlever le AAC1617, changer le freekote 44-NC pour le Wolo

 B69341
 B69341
 27 JUN 2011


Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

 Commentair Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
 N° 83634, Frekote Loctite Wolo # de Lot:

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009.

 Date: 6-6-11 Sceau: 

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

 Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-31135-1


4.0 AMB0286 Catalyst N° DDM-9


 Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

 du Gel coat 2%  Gel coat
 Faire la préparation de la résine selon les quantités requises; mix ratio 1.5% catalyst par quantité de résine.







 Date: 6-6-11 Sceau: 

B.C.

6/6/2011

Date: Lundi, 2011-05-09 17:47:01
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 33206		Numéro Article: DKC134-0013	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
6.0	GEL COAT	Application du Gel Coat	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'application du Gelcoat selon IG 0019			
Date: 6-6-11 Sceau: 			
7.0	AC0883	Tissu à délaminer Release ply B	
Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)			
8.0	AC0884	Wrightlon 5200 Bleu P3	
Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)			
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)			
10.0	AC0943	Stretchlon 200 poche à vide Vert	
Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)			
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2			
12.0	AMB0349	Fiberglass 12 oz Unidirectional	
Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s) Fiberglass 12 oz Unidirectional N° de Lot: 1-28549-1			
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)			
14.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Tailler le matériel, selon les différents patrons de découpe comme suit:			
4 plis de tissus de 9.7 oz.			
1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.			
3 fois le sac à vide Stretchlon 200.			
3 fois le film perforé P-3			
3 fois le feutre de drainage			
2 fois le tissu à délaminer (non nécessaire lors du bagging du core):			
Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.			
Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.			

Date: Lundi, 2011-05-09 17:47:01

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33206

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 6-6-11 Sceau: N.T.

15.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-31015-1

17.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 7-6-11 Sceau:

18.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 7-6-11 Sceau: A.M.

19.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 8:40 Heure Curing Fin: 3:40

Date: 7-6-11 Sceau: A.M.

Date: Lundi, 2011-05-09 17:47:01

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 33206

Numéro Article: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

28.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-31015-1

29.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 14/06/11

Sceau:



30.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 14/06/11

Sceau:



31.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 8:15

Heure Curing Fin: 4:00











Date: 14/06/11

Sceau:
















Date: Lundi, 2011-05-09 17:47:01
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 33206		Numéro Article: DKC134-0013	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
32.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Démouler la pièce en faisant bien attention aux coins & Edges.			
Date: <u>14/06/11</u> Sceau: 			
33.0	TRIMAGE	Trimage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de penture selon le dessin N° D2445.			
Date: <u>16/06/11</u> Sceau: 			
34.0	AAC1605	Label N° D0588-041	
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)			
Label N° D0588-041 N° de Lot: <u>1-31017-1</u>			
35.0	AAC1609	Surface Veil	
Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)			
Surface Veil N° de Lot: <u> </u>			
36.0	AAC1220	Résine Mia-Poxy 100	
Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)			
Résine Mia-Poxy 100 N° de Lot: <u>1-25679-1</u>			
37.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)			
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-25679-2</u>			
38.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Coller le label N° D0588-041 selon IG 0111.			
Date: <u>21-06-11</u> Sceau: 			

Date: Lundi, 2011-05-09 17:47:02
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 33206		Numéro Article: DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-31178-3</u>			
40.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.			
Date: <u>21-06-11</u> Sceau: 			
41.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-28961-2</u> <u>1-28961-2</u>			
42.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-29932-3</u> <u>1-29932-3</u>			
43.0	PRIMER	Application primer	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation et l'application du primer selon I.G. 0008			
Date: <u>22 juin 11</u> Sceau:  # de fiche de mélange: <u>n/a</u> <u>final</u> <u>Bâtisseur</u>			
44.0	INSPEC FINAL	Inspection finale	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection selon le dessin N° D2445.			
Date: <u>23 JUIN 11</u> Sceau: 			
45.0	EMBALLAGE	Emballage & Entreposage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'emballage des pièces selon IG 0057			
Date: <u>23 juin 11</u> Sceau: 			

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

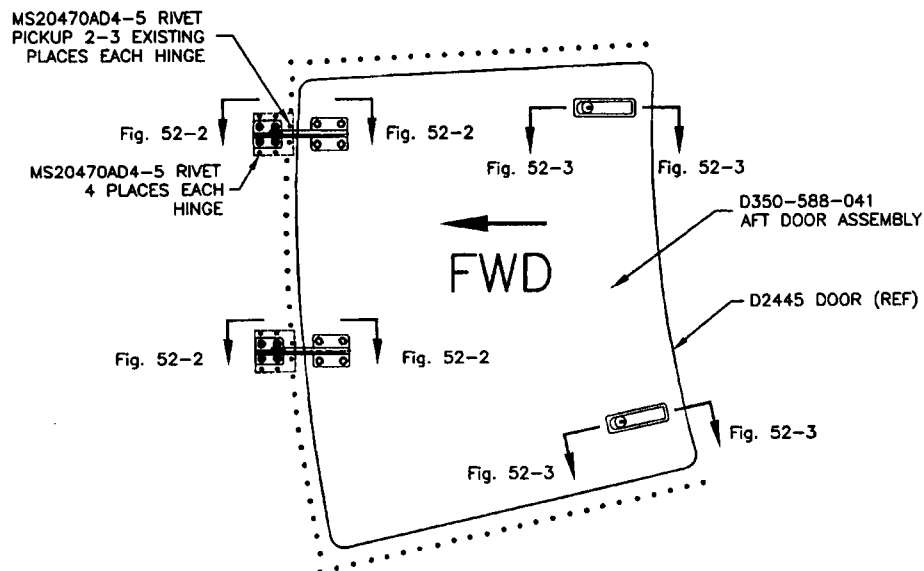
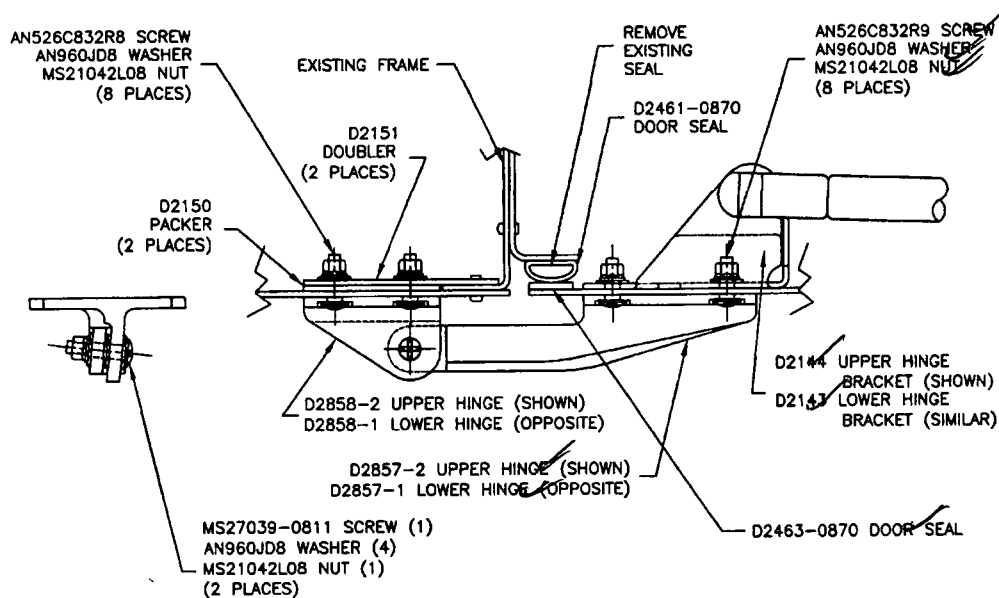
52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET qp/s.
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2 /
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8 /
4	4	MS21042L3	NUT (or MS21042-3) -2 /
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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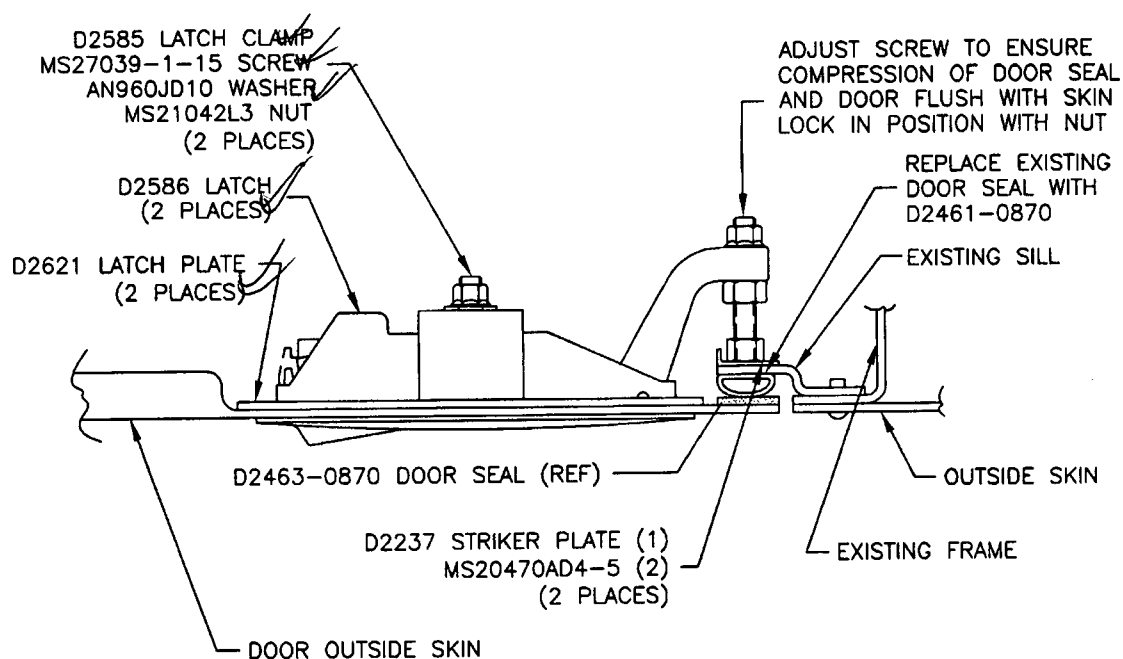
52-00-00

REFERENCE ONLY**Figure 52-1: Baggage Door Outside View****Figure 52-2: Hinge Detail**

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52-00-00

REFERENCE ONLY**Figure 52-3: Latch Section**

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